

Thursday, August 07, 2014 11:17:29 AM

Page 1

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

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Page 2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Work Order ID 123509

123509

Page 3

Thursday, August 07, 2014 11:17:29 AM

Item ID: D3574-2 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Cabin Floor Protector

Start Date: 8/04/14 Start Qty: 1.00 *1*

Required Date: 8/07/14 Req'd Qty: 1.00 *1*

Reference: Cust Item ID: Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | Identify as per dwg & Stock Location <u>P/C</u> | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

OCT 15 2014

DAS
06
9-89

14/10/16

MF

14-10-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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|--|--|---|--|

Picklist Print

Thursday, August 07, 2014 11:17:29 AM

Page 1

Work Order ID: 123509

123509

Parent Item: D3574-2

D3574-2

Parent Item Name: Cabin Floor Protector

Start Date: 8/04/14

Required Date: 8/07/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

MLEXS.125-F60029-04

Purchased

No

sf

5,710.525

26

MI FXS 125-F60029-04

26 14/10/15

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT019

3150.525

124866

106

m126425

160.925

m127934

699.6

m128746

2184

TPI

2560

m129759

2560

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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| Training | | | | | | | | | |
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|--|--|---|--|

| | | |
|--|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 123509 |
| Description: Cabin Floor Protector | | Part Number: D3574-2 |
| Inspection Dwg: D3574 Rev: B | | Page 1 of 2 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø3.00 | +0.006/-0.001 | Ø 2.59 | ✓ | | U Oc107 | |
| 7.37 | +/-0.030 | 7.35 | ✓ | | T Oc117 | |
| 10.75 | +/-0.030 | 10.75 | ✓ | | | |
| 11.00 | +/-0.030 | 11.02 | ✓ | | | |
| 15.25 | +/-0.030 | 15.25 | ✓ | | | |
| 25.87 | +/-0.030 | 25.85 | ✓ | | | |
| 39.75 | +/-0.030 | 39.78 | ✓ | | | |
| 44.75 | +/-0.030 | 44.75 | ✓ | | | |
| 53.51 | +/-0.030 | 53.53 | ✓ | | | |
| 63.50 | +/-0.030 | 63.500 | ✓ | | | |
| 65.25 | +/-0.030 | 65.25 | ✓ | | | |
| 10.75 | +/-0.030 | 10.75 | ✓ | | | |
| 11.00 | +/-0.030 | 11.00 | ✓ | | | |
| 14.75 | +/-0.030 | 14.75 | ✓ | | | |
| 25.50 | +/-0.030 | 25.500 | ✓ | | | |
| 25.75 | +/-0.030 | 25.75 | ✓ | | | |
| 26.00 | +/-0.030 | 26.00 | ✓ | | | |
| 32.87 | +/-0.030 | 32.85 | ✓ | | | |
| 38.81 | +/-0.030 | 38.80 | ✓ | | | |
| 45.00 | +/-0.030 | 45.00 | ✓ | | | |
| 48.25 | +/-0.030 | 48.25 | ✓ | | | |
| 58.38 | +/-0.030 | 58.40 | ✓ | | | |
| 61.25 | +/-0.030 | 61.25 | ✓ | | | |
| 64.13 | +/-0.030 | 64.10 | ✓ | | | |
| 64.63 | +/-0.030 | 64.60 | ✓ | | | |
| 66.50 | +/-0.030 | 66.50 | ✓ | | | |
| 7.50 | +/-0.030 | 7.50 | ✓ | | | |
| 9.50 | +/-0.030 | 9.50 | ✓ | | | |
| 10.38 | +/-0.030 | 10.40 | ✓ | | | |
| 10.88 | +/-0.030 | 10.89 | ✓ | | | |
| 14.50 | +/-0.030 | 14.50 | ✓ | | | |
| 16.56 | +/-0.030 | 16.56 | ✓ | | | |
| 18.75 | +/-0.030 | 18.75 | ✓ | | | |
| 24.13 | +/-0.030 | 24.10 | ✓ | | | |

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 123509 |
| Description: Cabin Floor Protector | | Part Number: | D3574-2 |
| Inspection Dwg: D3574 Rev: B | | Page 2 of 2 | |

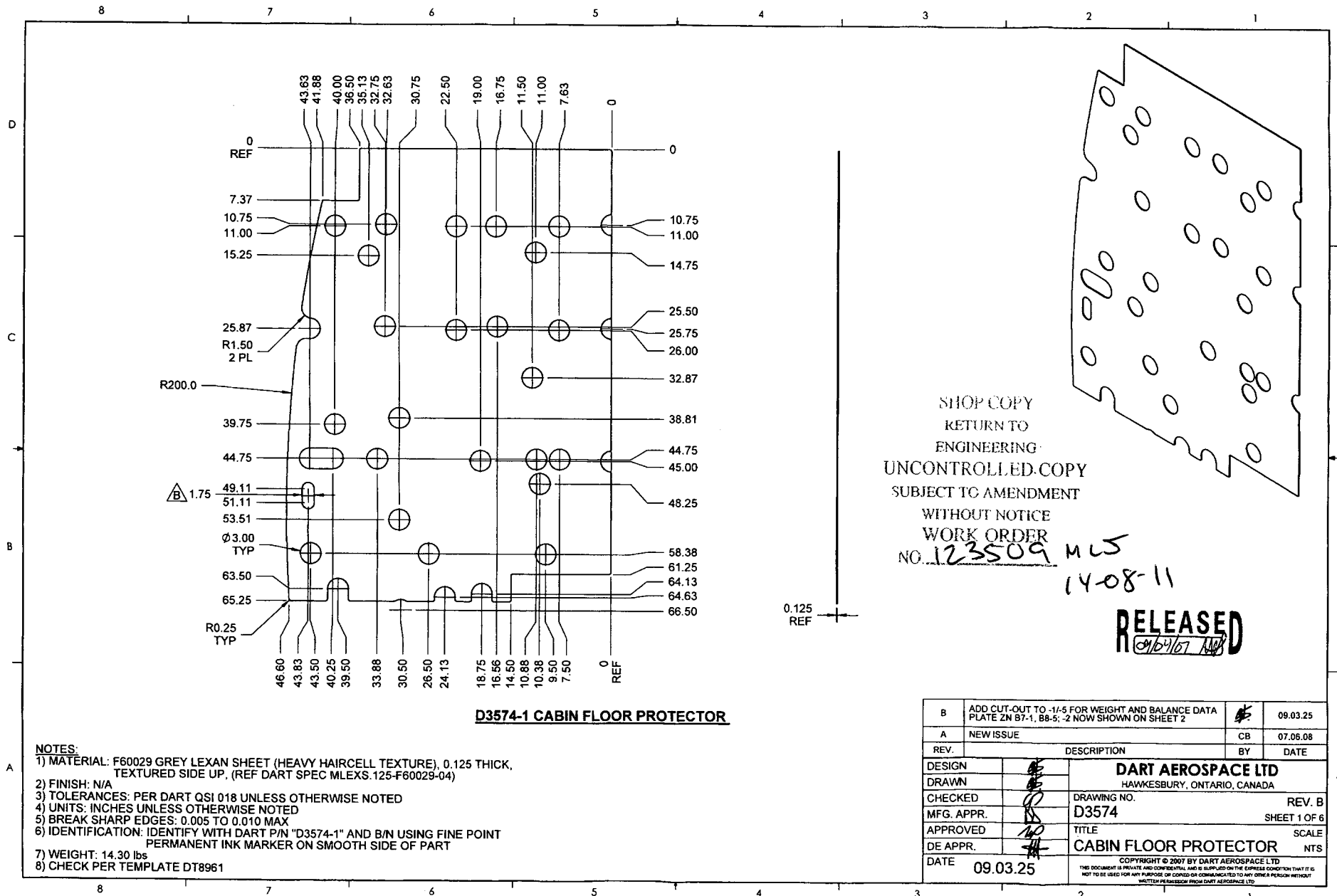
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 26.50 | +/-0.030 | 26.50 | / | | V=Jkm-01 | |
| 30.50 | +/-0.030 | 30.50 | / | | T=Jkm-06 | |
| 33.88 | +/-0.030 | 33.88 | / | | | |
| 39.50 | +/-0.030 | 39.50 | / | | | |
| 40.25 | +/-0.030 | 40.25 | / | | | |
| 43.50 | +/-0.030 | 43.50 | / | | | |
| 46.60 | +/-0.030 | 46.60 | / | | | |
| 7.63 | +/-0.030 | 7.63 | / | | | |
| 11.00 | +/-0.030 | 11.00 | / | | | |
| 11.50 | +/-0.030 | 11.50 | / | | | |
| 16.75 | +/-0.030 | 16.75 | / | | | |
| 19.00 | +/-0.030 | 19.00 | / | | | |
| 22.50 | +/-0.030 | 22.50 | / | | | |
| 30.75 | +/-0.030 | 30.75 | / | | | |
| 32.63 | +/-0.030 | 32.63 | / | | | |
| 32.75 | +/-0.030 | 32.75 | / | | | |
| 35.13 | +/-0.030 | 35.13 | / | | | |
| 36.50 | +/-0.030 | 36.50 | / | | | |
| 40.00 | +/-0.030 | 40.00 | / | | | |
| 41.88 | +/-0.030 | 41.88 | / | | | |
| 43.63 | +/-0.030 | 43.63 | / | | | |
| 0.125 | +/-0.010 | 0.125 | / | | | |

| | | | |
|---|------------------------------------|----------------------------|-----|
| Measured by: <i>DC</i> ³⁸ ₉₋₈₉ | Audited by: ⁹⁻⁸⁹ | Prototype Approval: | N/A |
| Date: 14/10/15 | Date: 14-10-16 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 08.02.28 | New Issue | KJ/DD | |
| B | 08.07.31 | 47.75 dimension removed | KJ/DD | |
| C | 09.05.15 | Dimensions updated per Dwg Rev B | KJ | |

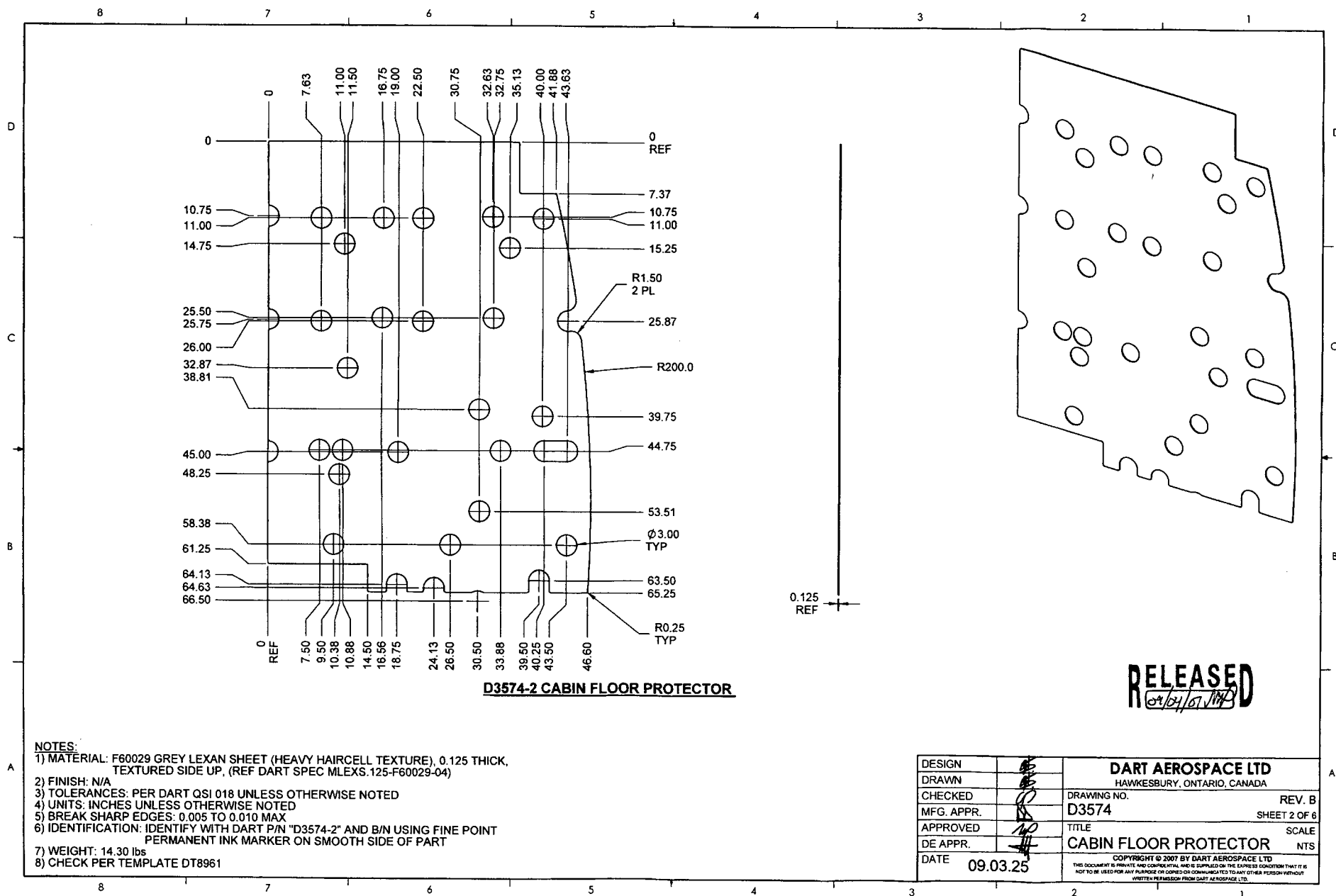


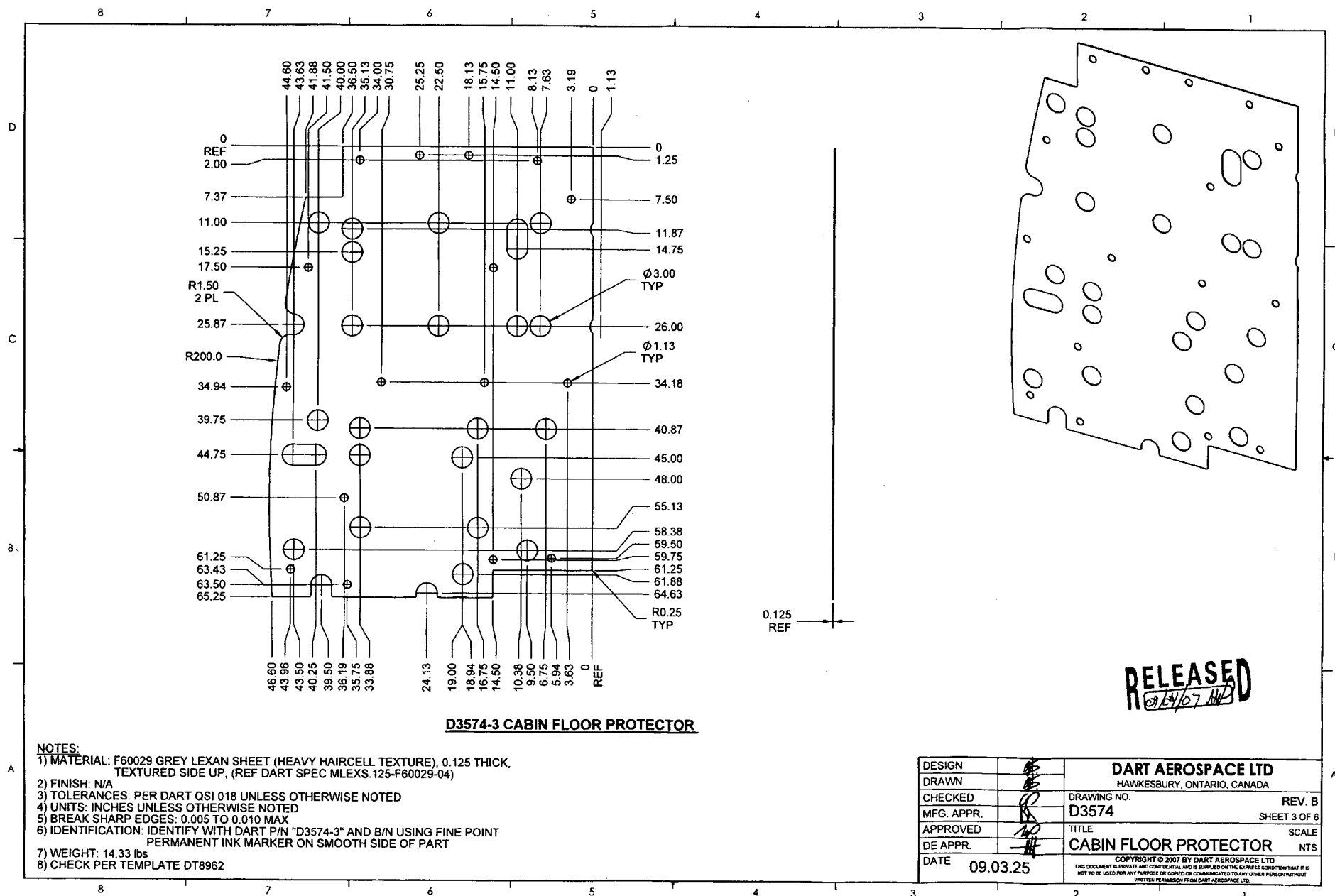
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WORK ORDER
NO. 123509 MLS
14-08-11

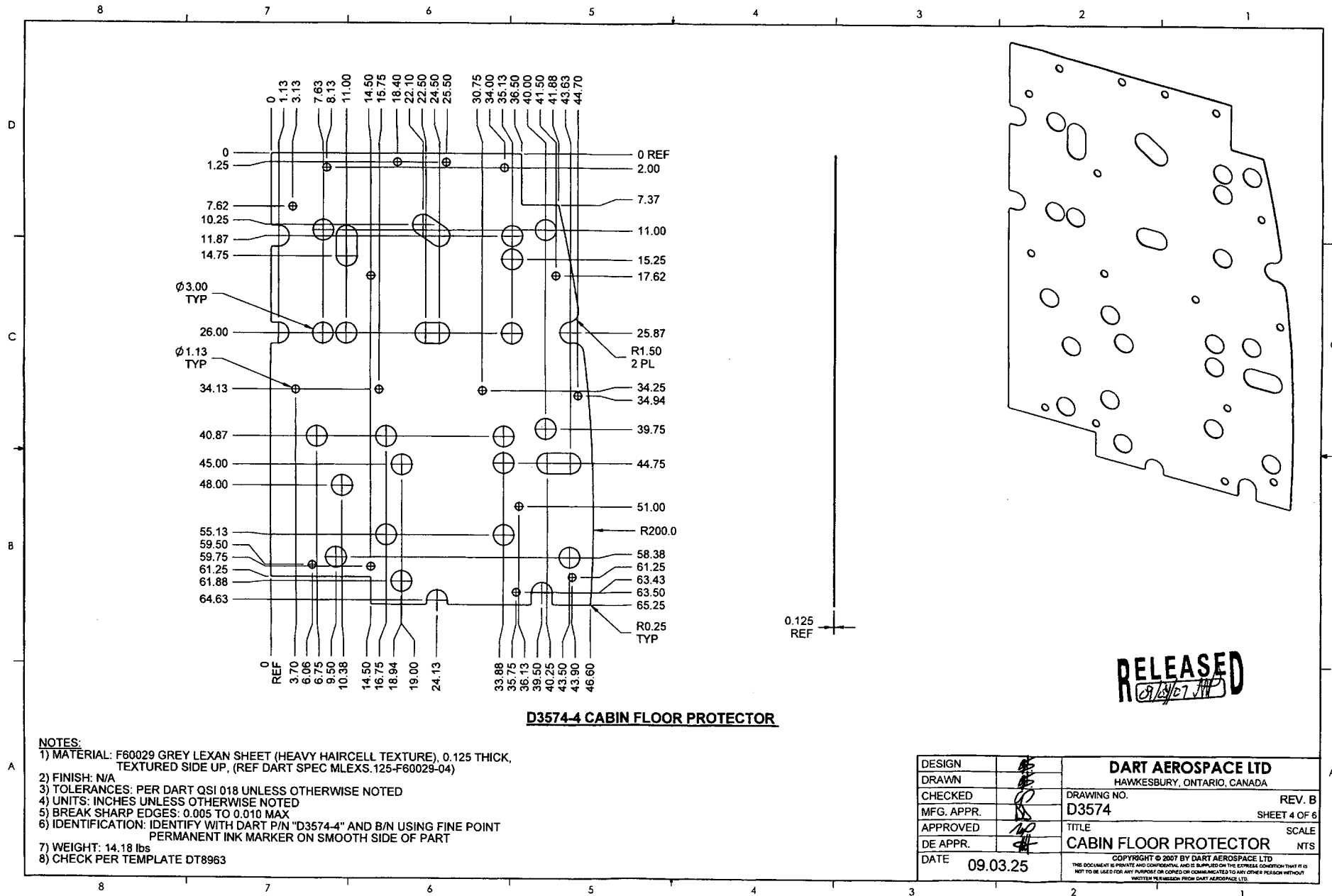
RELEASED
01/07/11

| | | |
|------------|---|-------------|
| B | ADD CUT-OUT TO -1/5 FOR WEIGHT AND BALANCE DATA PLATE ZN 87-1, B8-5; -2 NOW SHOWN ON SHEET 2 | 09.03.25 |
| A | NEW ISSUE | CB 07.06.08 |
| REV. | DESCRIPTION | BY DATE |
| DESIGN | | |
| DRAWN | | |
| CHECKED | | |
| MFG. APPR. | | |
| APPROVED | | |
| DE APPR. | | |
| DATE | 09.03.25 | |

| | |
|---|------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | REV. B SHEET 1 OF 6 |
| DRAWING NO. D3574 | SCALE NTS |
| TITLE CABIN FLOOR PROTECTOR | |
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RELEASED
8/2/07

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-4" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.18 lbs
- 8) CHECK PER TEMPLATE DT8963

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3574 | SHEET 4 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CABIN FLOOR PROTECTOR | NTS |
| DATE | 09.03.25 | <small> COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small> | |

